

AMENDMENT OF SOLICITATION/MODIFICATION OF CONTRACT				1. CONTRACT ID CODE See Block #2		PAGE OF PAGES 1 of 2									
2. AMENDMENT/MODIFICATION NO. 0007		3. EFFECTIVE DATE 11 SEP 2003		4. REQUISITION/PURCHASE REQ.NO.		5. PROJECT NO. (If applicable)									
6. ISSUED BY AEDC PKP CODE AEDC/PAK 100 KINDEL DRIVE, SUITE A-332 ARNOLD AFB, TN 37389-1332 KAREN J. BUCKNER 931-454-4405 karen.buckner@arnold.af.mil		7. ADMINISTERED BY (If other than Item 6) CODE													
8. NAME AND ADDRESS OF CONTRACTOR (No., street, county, State and ZIP Code) ALL PROSPECTIVE OFFERORS				(X)		9A. AMENDMENT OF SOLICITATION NO. F40650-03-R-0051									
				X		9B. DATED (SEE ITEM 11) 09 JUL 2003									
						10A. MODIFICATION OF CONTRACT/ORDER NO.									
						10B. DATED (SEE ITEM 13)									
CODE		FACILITY CODE													
11. THIS ITEM ONLY APPLIES TO AMENDMENTS OF SOLICITATIONS															
<input checked="" type="checkbox"/> The above numbered solicitation is amended as set forth in Item 14. The hour and date specified for receipt of Offers <input checked="" type="checkbox"/> is extended, <input type="checkbox"/> is not extended. Offers must acknowledge receipt of this amendment prior to the hour and date specified in the solicitation or as amended, by one of the following methods: (a) By completing Items 8 and 15, and returning 0 copies of the amendment; (b) By acknowledging receipt of this amendment on each copy of the offer submitted; or (c) By separate letter or telegram which includes a reference to the solicitation and amendment numbers. FAILURE OF YOUR ACKNOWLEDGMENT TO BE RECEIVED AT THE PLACE DESIGNATED FOR THE RECEIPT OF OFFERS PRIOR TO THE HOUR AND DATE SPECIFIED MAY RESULT IN REJECTION OF YOUR OFFER. If by virtue of this amendment you desire to change an offer already submitted, such change may be made by telegram or letter, provided each telegram or letter makes reference to the solicitation and this amendment, and is received prior to the opening hour and date specified.															
12. ACCOUNTING AND APPROPRIATION DATA (If required)															
13. THIS ITEM APPLIES ONLY TO MODIFICATION OF CONTRACTS/ORDERS, IT MODIFIES THE CONTRACT/ORDER NO. AS DESCRIBED IN ITEM 14.															
<input checked="" type="checkbox"/> <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">A.</td> <td>THIS CHANGE ORDER IS ISSUED PURSUANT TO: () THE CHANGES SET FORTH IN ITEM 14 ARE MADE IN THE CONTRACT ORDER NO. ITEM 10A.</td> </tr> <tr> <td>B.</td> <td>THE ABOVE NUMBERED CONTRACT/ORDER IS MODIFIED TO REFLECT THE ADMINISTRATIVE CHANGES (such as changes in paying office, appropriation data, etc.) SET FORTH IN ITEM 14, PURSUANT TO THE AUTHORITY OF FAR 43.103(b).</td> </tr> <tr> <td>C.</td> <td>THIS SUPPLEMENTAL AGREEMENT IS ENTERED INTO PURSUANT TO AUTHORITY OF:</td> </tr> <tr> <td>D.</td> <td>OTHER (Specify type of modification and authority)</td> </tr> </table>								A.	THIS CHANGE ORDER IS ISSUED PURSUANT TO: () THE CHANGES SET FORTH IN ITEM 14 ARE MADE IN THE CONTRACT ORDER NO. ITEM 10A.	B.	THE ABOVE NUMBERED CONTRACT/ORDER IS MODIFIED TO REFLECT THE ADMINISTRATIVE CHANGES (such as changes in paying office, appropriation data, etc.) SET FORTH IN ITEM 14, PURSUANT TO THE AUTHORITY OF FAR 43.103(b).	C.	THIS SUPPLEMENTAL AGREEMENT IS ENTERED INTO PURSUANT TO AUTHORITY OF:	D.	OTHER (Specify type of modification and authority)
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C.	THIS SUPPLEMENTAL AGREEMENT IS ENTERED INTO PURSUANT TO AUTHORITY OF:														
D.	OTHER (Specify type of modification and authority)														
E. IMPORTANT: Contractor <input type="checkbox"/> is not, <input type="checkbox"/> is required to sign this document and return _____ copies to the issuing office.															
14. DESCRIPTION OF AMENDMENT/MODIFICATION (Organized by UCF section headings, including solicitation/contract subject matter where feasible.) See page 2.															
Except as provided herein, all terms and conditions of the document referenced in Item 9A or 10A, as heretofore changed, remains unchanged and in full force and effect.															
15A. NAME AND TITLE OF SIGNER (Type or print).				16A. NAME AND TITLE OF SIGNER (Type or print) KATHY P. SWANSON											
15B. CONTRACTOR/OFFEROR		15C. DATE SIGNED		16B. UNITED STATES OF AMERICA		16C. DATE SIGNED									
_____ (Signature of person authorized to sign)				BY _____ (Signature of Contracting Officer)											

1. The purpose of this amendment is to

a. Incorporate the revised schedule as follows:

CLIN 0001. Provide all labor and materials to retrofit the CNC Controller Retrofit for the 6-Axis Henri Line Gantry Mill. The contractor shall provide the CNC control equipment and spare parts as detailed in Attachment 2, Major Control Items, dated 10 Sep 03. Provide any wiring of control equipment. Provide any hardware and software engineering as required to allow the CNC to properly control the machine. Provide wiring of machine to CNC and to drives, etc to make the machine operational. Provide checkout and replacement for any drives or other defective components. After completion of the integration, the contractor shall laser calibrate the X, Y, and Z-axes and enter the calibration data into the CNC. The operator panel shall be mounted in same place as the existing control panel. A jog pendant with a Hand Pulse Generator (HPG) and selector switches for speed and axis select will be mounted by curly cord near the operator panel. Provide Tool Center Point Control Programming feature. The Contractor shall be responsible for making the machine operational. The Contractor shall warrant all parts and labor for a period of not less than one year.

CLIN 0002. Provide Programming Package to include the Input of Machine Control Files (i.e. CNC Programs) via a PC Data Card to be installed by the Contractor.

CLIN 0003. Provide Operation Manual to include as a minimum all instructions for operating the controller.

CLIN 0004. Provide Maintenance Manual to include as a minimum B-size wiring diagram of machine, AMP parameter listing, PAL source listing, I/O listing, PAL source (on 3.5" floppy), and AMP source (on 3.5" floppy).

CLIN 0005. Upgrade 5 analog Fanuc servo drive motors and corresponding analog drive controllers (X, Y, Z, A, C) to digital servo and digital servo amplifiers. The analog spindle, w-axis, and v-axis (tool changer) will remain analog.

CLIN 0006. Provide eight (8) hours of operator training to at least two, but no more than four, contractor employees.

b. To incorporate AEDC Clause AEDC-K001, Electronic Proposals (Aug 2003). Proposals will be accepted electronically in accordance with FAR Part 15.208, Submission, Modification, Revision, and Withdrawal of Proposals. Proposals may be emailed to Ms. Karen Buckner at karen.buckner@arnold.af.mil.

2. The proposal due date is to be extended to 22 September 2003, at 4:30 PM CST.

ATTACHMENT 2

MAJOR CONTROL ITEMS

QTY	DESCRIPTION
1	<i>Fanuc 16i-MB with 10.4 inch color LCD display</i>
1	Seven servo axes
1	Split servo capability
1	Software over travel before move
1	Part program restart
1	Tool retract and recovery
1	HPG program path interrupt
1	Thread cutting and feed per revolution
1	Probing capability
1	Linear Acc/Dec before interpolation
1	Work coordinates
1	Programmable data input
1	Custom Macro
1	Programmable mirror image
1	Analog spindle interface
1	Second misc. function
1	Rigid tapping
1	32 Tool offsets
1	Tool offset memory C
1	Tool life management
1	Tool length measurement
2	1280 meter part storage
1	Canned cycles including deep hole & tapping
1	Part program editing.
1	Manual hand pulse generator interrupt
1	Operator panel w/ 0-150% FRO & 50-120% SSO
1	Standard features including diagnostics & backlash comp.
1	10 slot I/O rack
5	24 VDC 16 point input module
4	Output module (combination of DC, Relay, and AC)
1	24VDC power supply
1	Jog pendant
1	Manual set on CD ROM